

Date: Tuesday, 23/12/2008 1:22:44 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : RING  
 Job Number : 44295  
 Estimate Number : 10608  
 P.O. Number :  
 This Issue : 23/12/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : PURCHASED PARTS  
 Previous Run : 34752  
 Written By :  
 Checked & Approved By :  
 Comment : Est. D 00.06.22 Removed P/O for powder coat EC  
 Est Rev:E Now on Waterjet 06-10-04 JLM

Part Number : D2655  
 Drawing Number : D2655 REV B  
 Project Number : N/A  
 Drawing Revision : B  
 Material :  
 Due Date : 05/01/2009 Qty: 20 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1018B400X250 1018 bar 4.00 x .250



out of MAT

Comment: Qty.: 0.2835 f(s)/Unit Total: 5.6700 f(s)

1018 ASTM A36 .250" thk bar x 4.0"

Batch: 109794

IB 9-1-26

IB 9-1-26

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2655

Dwg Rev: B

Prog Rev: B

IB 9-1-26

(18)

2-Deburr if necessary

IB 9-1-26

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



IB 9-1-26

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Sort 126 (18)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



(18X)

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble .030 Radius

2-Deburr any rough edges after tumbling

m. h. 06/01/27

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RING

Job Number: 44295

Part Number: D2655

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509/01/27 (+18)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat per QSI 005 4.3.5.1

START TIME:

7:35

OVEN TEMPERATURE:

400°

FINISH TIME:

8:05

(18)

FL 09/01/28

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-01-28

(18)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST463

09/01/28 (+18)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/02

Job Completion



U 09.01.30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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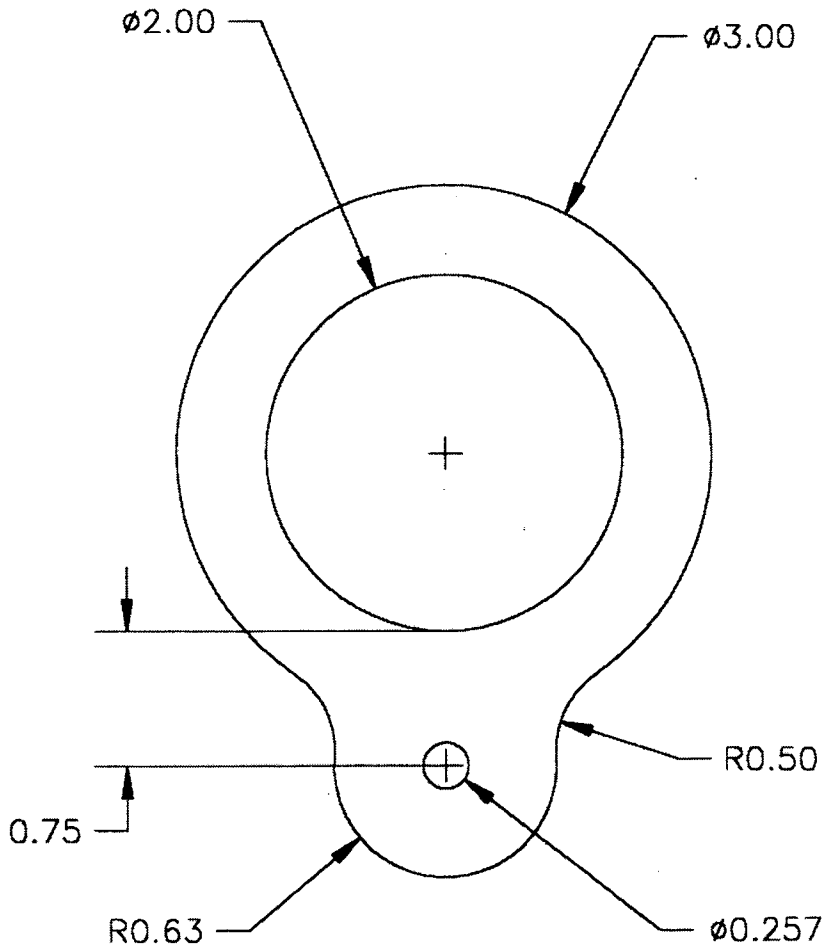
**NOTE:** Date & initial all entries





DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2655	REV. B SHEET 1 OF 1
DATE 97:07:07		TITLE RING	SCALE 1:1
A	97:03:25	NEW ISSUE	
B	97:07:07	ADD ASTM A36 TO MAT. SPEC.	

RELEASED  
47/07/11 DS



NOTE: DEBURR ALL SHARP EDGES  
MATERIAL: AISI 1018/1020/1025 OR ASTM A36 0.250 THICK  
FINISH: POWDER COAT PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries